

Work Order ID 57742

April 14, 2010 11:36:01 AM

Page 1

Item ID: D2198-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 14/04/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2198	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2198 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

304.063

B10-4-27

(15)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-4-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8106429

H14

P10-7

W/O: 57742		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/4/29	#120	Took Qty +1 For QC inspection template	S	10/4/29	81		S 10/4/29

Part No: D2198-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Bracket

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00	8/10/03			14	8		
Brake NC	Bend as per dwg D2198								
140 	QC5- Inspect part completeness to step on W/O	0.00	8/10/03			(X14)			
QC	Memo	0.00	11/14/07						
Quality Control	powder coat white (steel)		Start time: 8:45AM			10/03/04	X14		
144			oven temp: 400°F						
145	QC 3		stop time: 9:15AM						
150 	Identify as per dwg & Stock Location: _____	0.00	M-1 10/05/04			(14X)			
Packaging	Memo	0.00							
Packaging			8			10-5-5	SP	(14)	

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Revision ID:

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Item Name: Bracket

Start Date: 14/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/05 *[Signature]*

CL10/514

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April 14, 2010 11:36:05 AM

Page 1

Work Order ID: 57742



Parent Item: D2198-1



Parent Item Name: Bracket



Start Date: 14/04/2010

Required Date: 22/04/2010

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	16.5700	0.7895	2.0		
304/316 Sheet .063											14-4-27	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT20

16.57

113295

16.57

114467

114467

15

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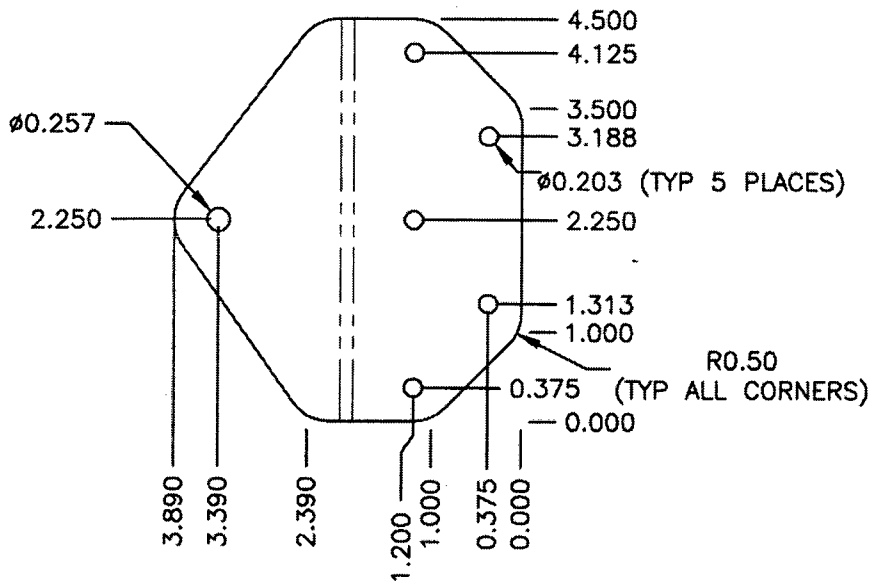
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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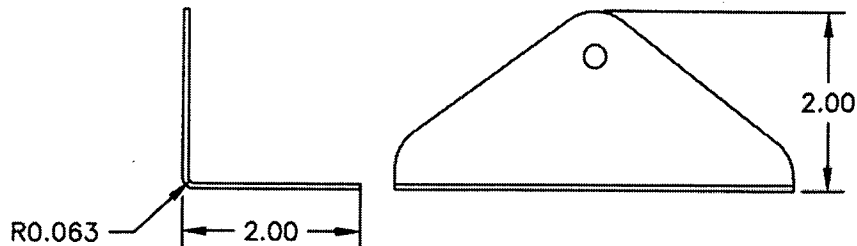
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2198	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.10.05	REDESIGN	
C	03.05.28	REDRAW	

RELEASED
03.07.09**D2198-1
FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57742

**D2198-1 BRACKET
BEND DETAIL****D2198-1**

- 1) MATERIAL: AISI 304/316 S.S. 0.064" THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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